

Date: Thursday, 8/23/2007 11:53:20 AM
 User: Kim Johnston

Process Sheet

Split into
8B 17/09/19

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ACCESS PANEL ASSEMBLY
 Job Number : 34241
 Estimate Number : 12949
 P.O. Number : *N/A* Part Number : D3259042
 This Issue : 8/23/2007 S.O. No. : *N/A* Drawing Number : D3249 REV A1
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : SMALL /MED FAB Drawing Revision : A1
 Previous Run : *N/A* Material : *N/A*
 Written By : *[Signature]* Due Date : 9/3/2007 Qty: *1* Um: Each
 Checked & Approved By : *[Signature]*
 Comment : Est Rev: A New Issue 07-07-19 JLM Verified By: EC

Additional Product

Job Number:



Seq. #

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Assembly Kit

2.0

D32591

panel



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 panel
 Batch: *34250* *SP*

3.0

D32594

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Doubler
 Batch: *20768* *SP*

4.0

D32595

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Spacer
 Batch: *34253* *SP*

5.0

D32597

Door



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Door
 Batch: *23265* *20768* *7/9/20 SP* *34284*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/09/19	1	Split W/O	SB	07/09/19	1		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 34241

Part Number: D3259042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D31615

Hinge 9.9"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Hinge 9.9"

Batch: M33671

SO

7.0

D32601

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Spring

Batch: M33678

SO

8.0

127H5

HALF GROMMET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

HALF GROMMET

Batch: M15058

SO

9.0

250018C3Y

RIGHT RECEPTACLE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

RIGHT RECEPTACLE

Batch: M100039

SO

10.0

2501W20020C3Y

STUD



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

STUD

Batch: M15131

SO

11.0

MS20426AD44

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Rivet

Batch: M1021

SO

12.0

MS20470AD34

Rivet, Universal Head



Comment: Qty.: 36.0000 Each(s)/Unit Total: 144.0000 Each(s)

Rivet, Universal Head

Batch: M15541

7/9/20 SO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/09/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 34241

Part Number: D3259042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS20470AD35

Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total : 40.0000 Each(s)

Rivet

Batch: 19682

7/9/20 50

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble D3259-041 as per Dwg D3259.
Note: Keep .040" Gap all around door.

ml 09/09/21 x1

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 2/08/21

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 07/9/21

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12 07/09/24

Job Completion



u 8/8/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

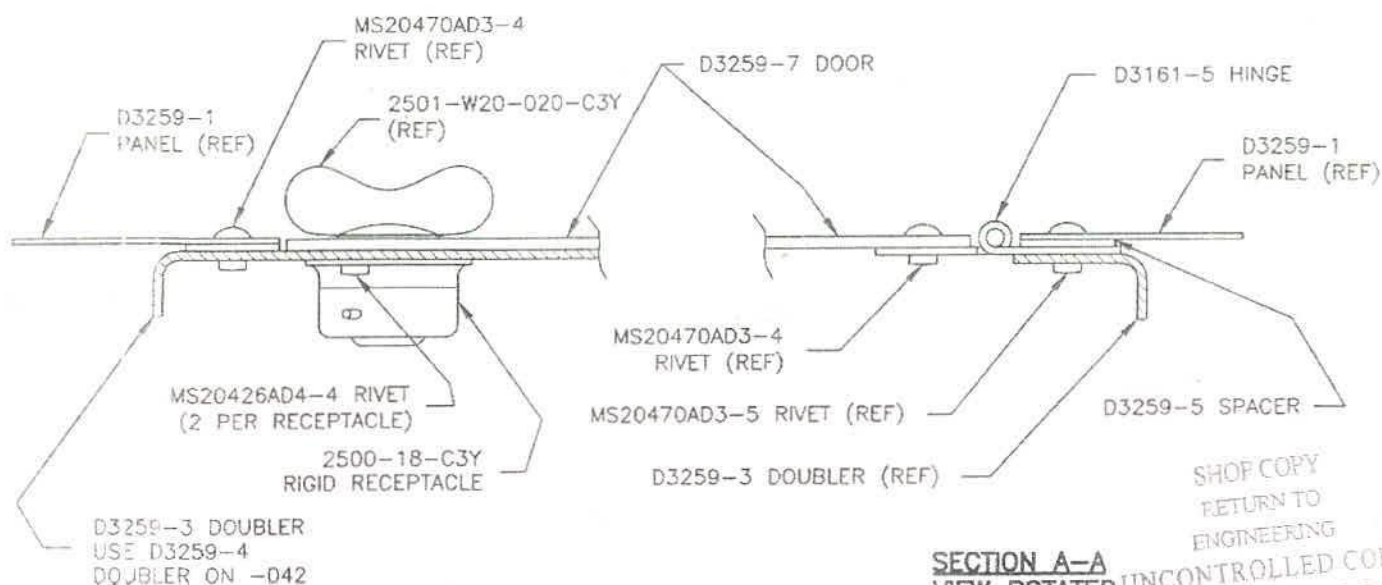
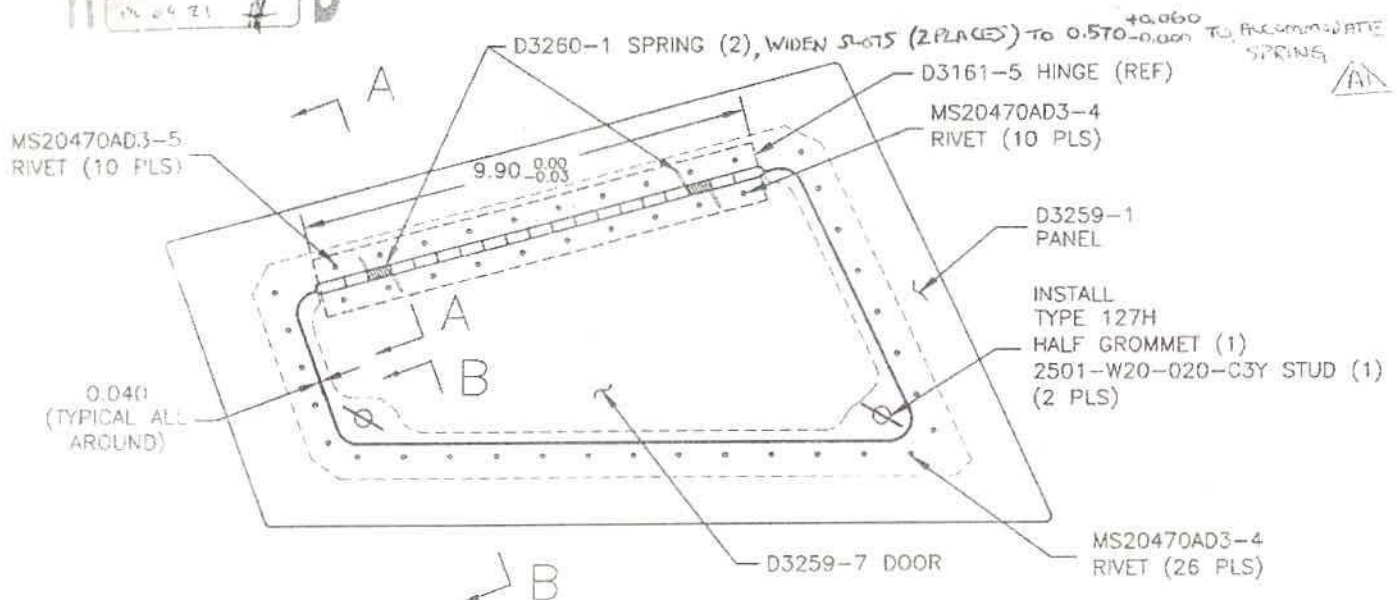
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	RF	DRAWN BY	CP	DART AEROSPACE LTD	REV. A
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	APPROVED	JP	DRAWING NO.	SHEET 1 OF 6
				D3259	
DATE	04.02.25	TITLE	ACCESS PANEL ASSEMBLY	SCALE	1:4
A	04.02.25	NEW ISSUE			
A1	04.08.11	WIDEN SLOTS TO ALLOW OPERATION OF SPRING			



SECTION B-B
VIEW ROTATED

SECTION A-A
VIEW ROTATED

D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)
D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

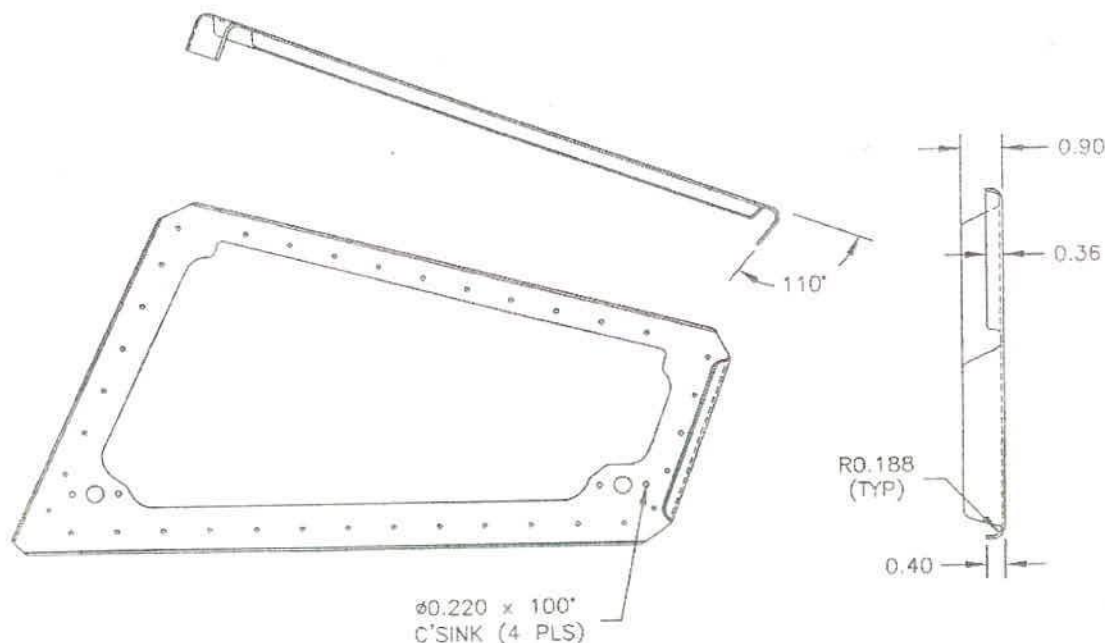
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WORK ORDER
NO. 3424

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DART

DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3259	REV. A SHEET 3 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14**D3259-3 DOUBLER BEND DETAIL (SHOWN)**

BEND D3259-4 DOUBLER (OPPOSITE)

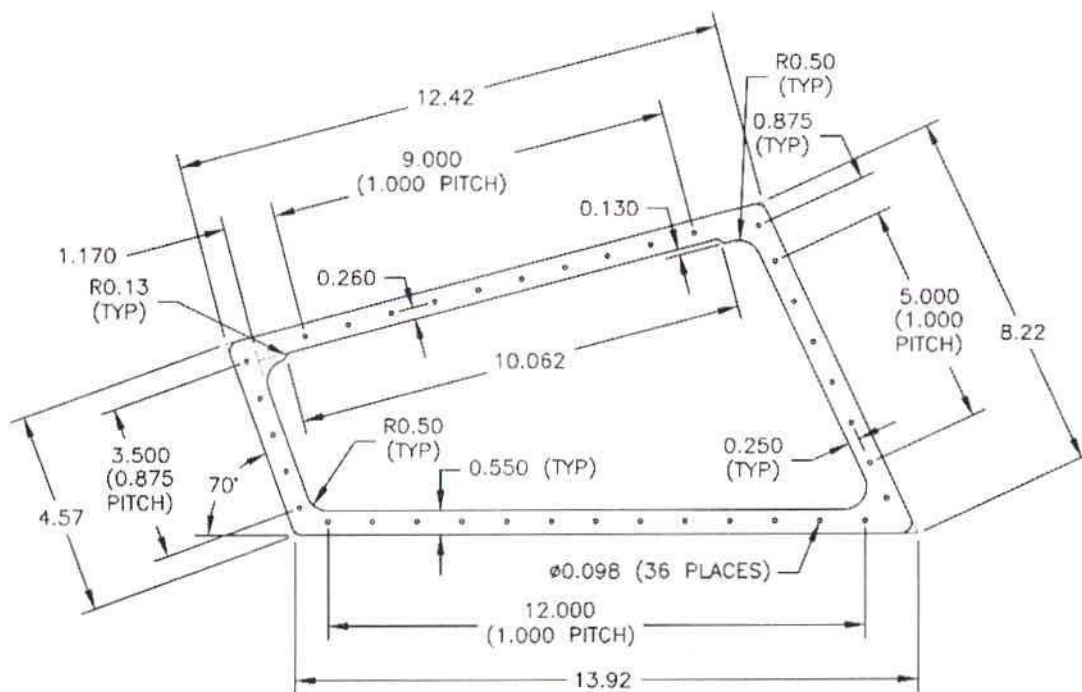
D3259-3/-4 NOTES:

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

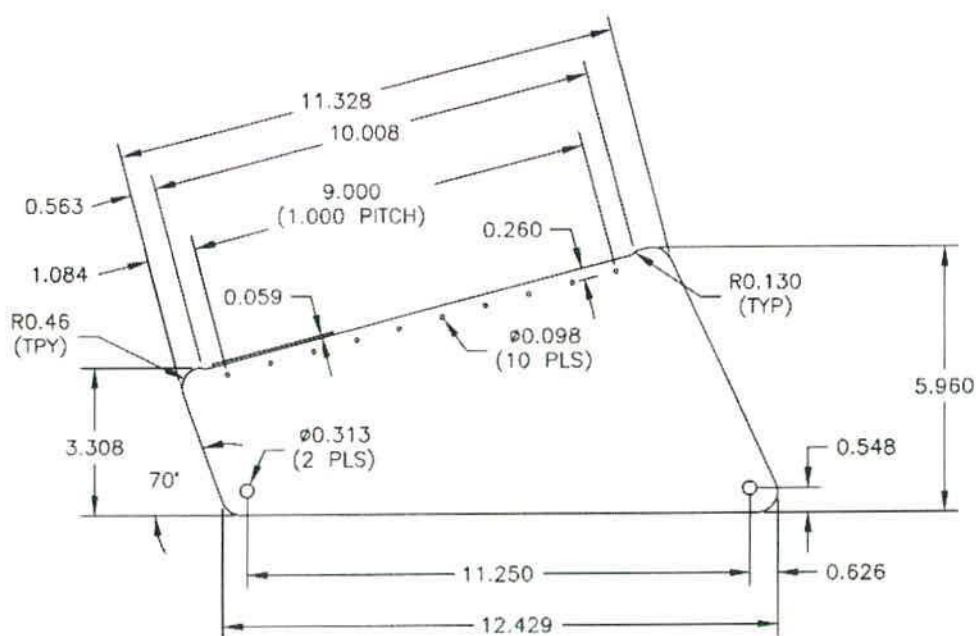
- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED	APPROVED	DRAWING NO. D3259	REV. A SHEET 6 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED



D3259-7 DOOR

NOTES:

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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